

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-006129**Date Inspected:** 15-Mar-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Peng Guo / Liu Zhongan / Huang Li			CWI Present:	Kai	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	TOWER COMPONENTS		

Summary of Items Observed:

On this date, the Caltrans OSM Quality Assurance (QA) Inspector, "Victor" KS Narayanan was present during the times noted above for observations relative to work performed.

Bay 11 – Tower Assembly

I. Lift 3 – Skin Plates' butt welding:

Weld process, SAW of butt weld joints located on PCMK: Lift 3-East & West Tower Skin plate butt welds. The weld designation numbers and welders were identified as follows.

- (1) ESD1-FESA3-2E/E-24A,39A – skin "A": The welder was identified Xia Yongzhong as and the welder number was identified as 040625.
- (2) ESD1-FESA3-2A/D— skin "D": The welder was identified as Shen Mei and the welder number was identified as 041716.
- (3) WSD1-FCSA3-2B/C-12A(CJP) – skin "D": The welder was identified as Yang Meizhan and the welder number was identified as 042195.

The ZPMC CWIs were identified as Li Ming & Huang Li and the ABF representatives were identified as Zhao Xianhe & Xie Yan. The welding variables recorded by QC appeared to comply with applicable WPS, WPS-B-T-2221-B-P3-S-Z for PJP weld joints & WPS-B-T-2221-B-U3C-S-Z for CJP weld joints.

II. Base Shear plate to Stiffeners' welding:

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Weld process, FCAW of weld joints located on PCMK SD1-A20A/B. The welder numbers were identified as 049220 (Xu Hua) for weld joints # 5 & 6, 048810 (Li Zhaoqian) for weld joints # 7 & 9, 202821 (Liu Jin) for weld joint # 10 and 047701 (Li Haidong) for weld joint # 11. The ZPMC CWI was identified as Huang Li and ABF representative was identified as You Yuanmao. The welding variables recorded by QC appeared to comply with applicable WPS, WPS-B-T-2332-Tc-P5-F for PJP weld joints.

Bay 10 – Tower Assembly:

I. Face A Base Shear plate to Stiffeners' welding:

Weld process, FCAW of weld joints located on PCMK ND1-A26A/B. The welder numbers were identified as 050041 for weld joints # 5 & 6, 201825 for weld joints # 7 & 8, 040427 for weld joint # 9. The ZPMC CWI was identified as Liu Zhongan and ABF representative was identified as Zhang Qinjian. The welding variables recorded by QC appeared to comply with applicable WPS, WPS-B-T-2332-Tc-P5-F for PJP weld joints.

II. Struts' welding:

Weld process, SMAW of fillet weld joint located on PCMK – WD1-A467-38M-3-1A & 4A. The corresponding welder numbers for these joints were identified as 05277 & 040333 respectively.

The ZPMC CWI was identified as Wu Ming Kai and the ABF representative was identified as Xiao Junpeng. The welding variables recorded by QC appeared to comply with applicable WPS, WPS-B-T-3212-Tc-U5b-1.

Bay 10 – Tower Assembly:

I. Ultrasonic Testing:

This QA Inspector performed 10% UT of area previously tested by ZPMC UT personnel. This QA Inspector generated a TL-6027 MT report on this date. The member was identified as Lift 3 – South Tower Skin “A” butt weld joint.

The weld designation number is as follows.

SSD1-FASA3-1A/E-2B

Unless otherwise noted, all observations on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

Comments: This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod (134-825-70045), who represents the Office of Structural Materials

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for your project.

Inspected By: Narayan, Victor

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer